

Work Order ID 52978

October 20, 2009 11:24:21 AM



ASAP

Page 1

Item ID: D3943-3

Accept



Setup Start

Revision ID: AB 09.10.10

Item Name: Handle Extension

Stop



Start Date: 10/21/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: mfDate: 09-10-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

09-10-22

FLOW CNC Waterjet

1-Cut as per Dwg D3943

Dwg Rev: 1Prog Rev: 1

2-Deburr if necessary

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

09-10-22

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52978

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Item ID: D3943-3

Accept

Revision ID: A

Item Name: Handle Extension

Start Date: 10/21/2009 Start Qty: 10.00

Required Date: 10/23/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

2) Sork/26

QC

Memo

0.00

Quality Control

130

Manufacture as per dwg

0.00

5/10/25

Mill Conv

Memo

0.00

Conventional Milling Machine

1-MILL DIMPLE USING 3/8" BALL

140

QC5- Inspect part completeness to step on W/O

0.00

~~5/10/25~~

QC

Memo

0.00

Quality Control

Sork/26

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss (Ref: 4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00

Yellow

Spray paint

~~Richard CG1031B~~

ml 09.11.03

(10)

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

QC14

170

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

ST139C

09.11.05

Pl 09 11 10

W/O:		WORK ORDER CHANGES					
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Run Start

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Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/10
mf
09-11-10

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Picklist Print

October 20, 2009 11:24:21 AM

Page 1

Work Order ID: 52978



Parent Item: D3943-3RevA



Parent Item Name: Handle Extension

Start Date: 10/21/2009

Required Date: 10/23/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M1010B0.500X03.000

Purchased

No

f

13.9600

12.6000



B8-10-22

1010-1025 BAR.500"x3.00"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.96

108336

1.96

112886

12

112886

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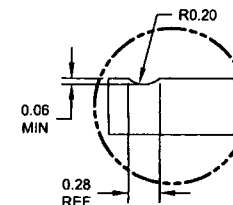
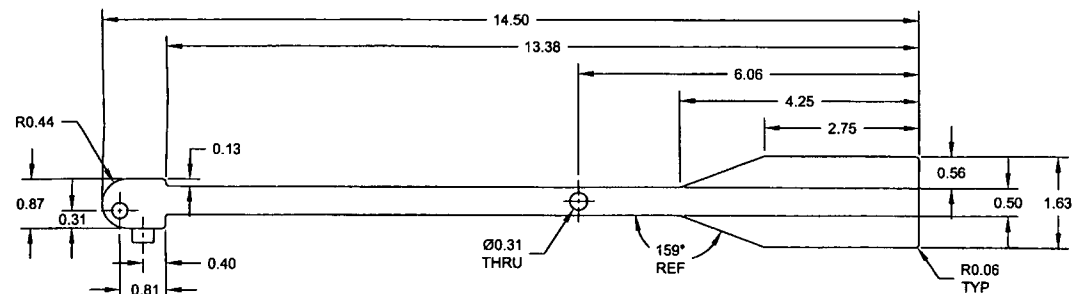
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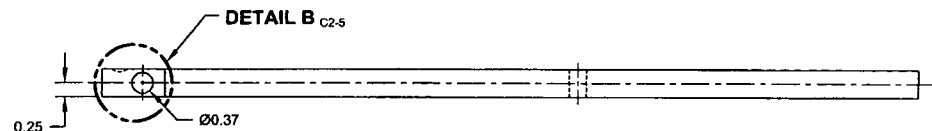
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8 7 6 5 4 3 2 1

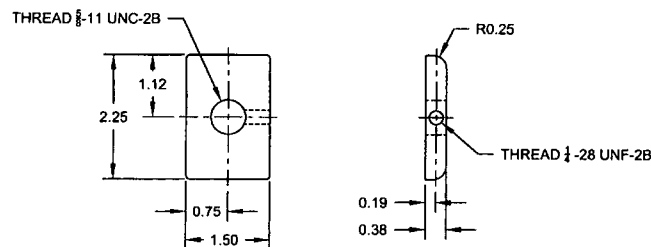


DETAIL B-B
(DIMPLE DETAIL)
(SCALE 2X)

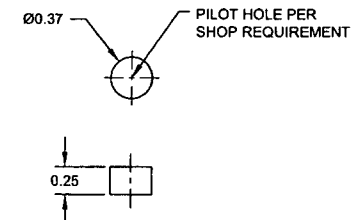


D3943-3 HANDLE EXTENSION

#52978



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR : MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

RELEASED
2009-10-19

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.10.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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